

Date: Wednesday, 9/6/2006 3:46:01 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD)
 Job Number : 28444
 Estimate Number : 10530
 P.O. Number : N/A Part Number : D2571
 This Issue : 9/6/2006 S.O. No. : N/A Drawing Number : D2571 REV E
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : E
 Previous Run : 27992 Material : N/A
 Due Date : 9/13/2006 Qty: 6 Um: Each
 Written By : [Signature]
 Checked & Approved By : [Signature] 06/09/06
 Comment : Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101007 7075-T7351 8.25X7.75X2.5



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
 7075-T7351 8.25X7.75X2.5
 Make from D6101-007 billet for D2571
 Ensure that grain is along 7.75" length
 Batch No: 1325354 9ml 06/09/18 6

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 Program Batch No 28444 Double check by: En 06/09/18
 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
 4-Deburr and remove all machining marks
 5-Tumble to remove sharp edges. 5.6 / 9ml 06/09/20 6

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE
 Machine keyway as per dwg D2571 & D2572 5.6 / 9ml 06/09/20 6

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE 5.6 / 9ml 06/09/21 6

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 8/18/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/6/2006 3:46:01 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 28444

Part Number: D2571

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En 06/07/27 x 6

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

06/09/27 x 6

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat GREEN (Ref: 4.3.5.1) as per QSI 005 4.3

06/09/28 x 6

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

PC 4/10/6 (6)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PPP 1/1000 3

PC 4/10/6 (6)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/10/06 (2)

Job Completion



u 06/10/06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	28444
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	✓	✓	✓	✓		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.499	3.499	3.500		
D	1.745	1.755		1.750	1.749	1.750	1.749		
E	7.990	8.010		8.005	8.002	8.002	8.002		
F	0.490	0.510		0.506	0.502	0.501	0.502		
G	0.257	0.262	DT8683	✓	✓	✓	✓		
H	0.375	0.380	DT8684	✓	✓	✓	✓		
I	0.490	0.510		0.500	0.495	0.497	0.498		
J	1.174	1.184		1.178	1.178	1.179	1.179		
K	0.558	0.578		0.568	0.569	0.567	0.567		
L	1.174	1.184		1.178	1.178	1.179	1.179		
M	1.490	1.500		1.492	1.497	1.497	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.871	3.871	3.871	3.873		
P	0.115	0.135		0.131	0.121	0.122	0.122		
Q	0.115	0.135		0.135	0.131	0.131	0.135		
R	0.240	0.260		0.253	0.249	0.248	0.247		
S	0.115	0.135		0.116	0.120	0.114	0.125		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.961	2.960		
V	0.230	0.250		0.238	0.238	0.237	0.241		
W	0.115	0.135		0.118	0.117	0.118	0.122		
X	0.308	0.313		0.310	0.310	0.310	0.309		
Y	0.760	0.765		0.760	0.761	0.761	0.760		
Z	0.352	0.372		0.355	0.362	0.362	0.362		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.627	0.625	0.629	0.631		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.244	0.249	0.249	0.245		
AE	1.375	1.395		1.389	1.385	1.384	1.385		
AF	0.115	0.135		0.126	0.133	0.134	0.130		
AG	0.240	0.280		0.250	0.260	0.260	0.260		
AH	0.240	0.260		0.249	0.248	0.247	0.250		
AI	2.000	2.020		2.001	2.003	2.003	2.001		
AJ	0.023	0.043		0.035	0.033	0.033	0.035		
Accept/Reject									

Measured by:	J.G / gmk
Date:	06/09/20

Audited by:	Er
Date:	06/09/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order: 28444
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	DT8682	—	—				
B	1.745	1.755		1.748	1.748				
C	3.495	3.505		3.499	3.499				
D	1.745	1.755		1.748	1.749				
E	7.990	8.010		8.002	8.002				
F	0.490	0.510		0.503	0.503				
G	0.257	0.262	DT8683	—	—				
H	0.375	0.380	DT8684	—	—				
I	0.490	0.510		0.500	0.499				
J	1.174	1.184		1.179	1.179				
K	0.558	0.578		0.568	0.565				
L	1.174	1.184		1.179	1.179				
M	1.490	1.500		1.495	1.495				
N	2.495	2.505		2.506	2.499				
O	3.869	3.879		3.872	3.872				
P	0.115	0.135		0.123	0.122				
Q	0.115	0.135		0.130	0.130				
R	0.240	0.260		0.248	0.247				
S	0.115	0.135		0.125	0.122				
T	0.178	0.198		0.188	0.188				
U	2.940	2.980		2.960	2.960				
V	0.230	0.250		0.243	0.239				
W	0.115	0.135		0.121	0.119				
X	0.308	0.313		0.311					
Y	0.760	0.765		0.760					
Z	0.352	0.372		0.369	0.367				
AA	0.470	0.530		0.500	0.500				
AB	0.615	0.635		0.633	0.633				
AC	0.053	0.073		0.063	0.063				
AD	0.240	0.260		0.245	0.244				
AE	1.375	1.395		1.384	1.388				
AF	0.115	0.135		0.130	0.136				
AG	0.240	0.280		0.245	0.245				
AH	0.240	0.260		0.250	0.246				
AI	2.000	2.020		2.000	2.002				
AJ	0.023	0.043		0.035	0.035				
Accept/Reject									






Measured by:	<i>RF</i>
Date:	06/09/21

Audited by:	<i>RF</i>
Date:	06/09/22

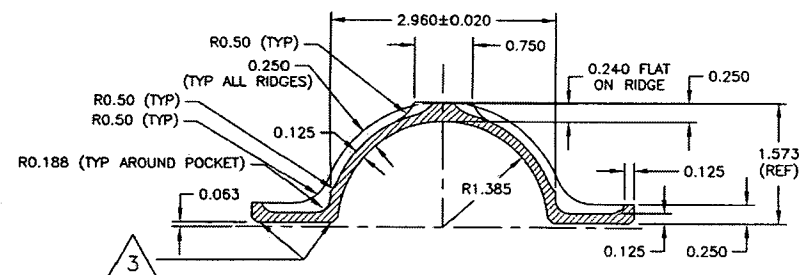
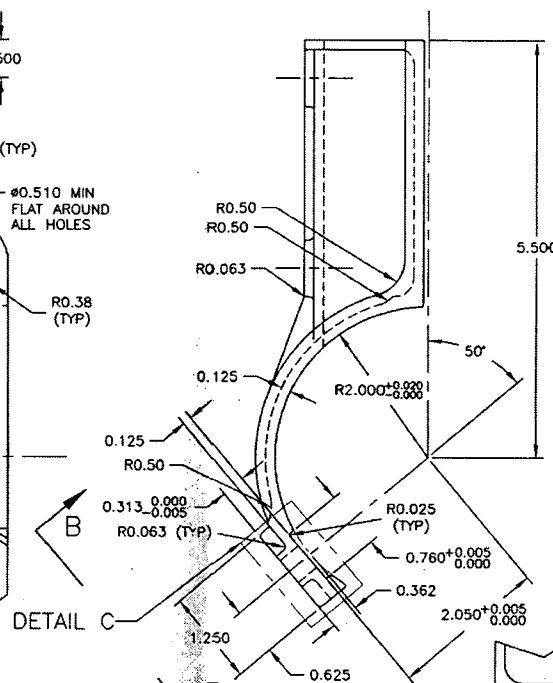
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>RF</i>

05.12.06

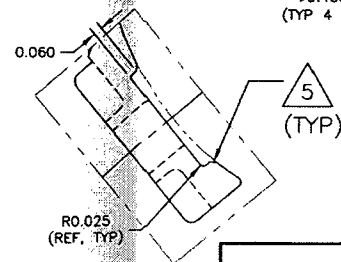
MATERIAL: 7075-17351 (QQ-A-250/12) (REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART
QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- | | |
|---|--|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
|  | ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125 |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES) |
|  | CHAMFER 0.063" x 45° ALL AROUND |
|  | CHAMFER 0.033" x 45° (SEE DETAIL C) |

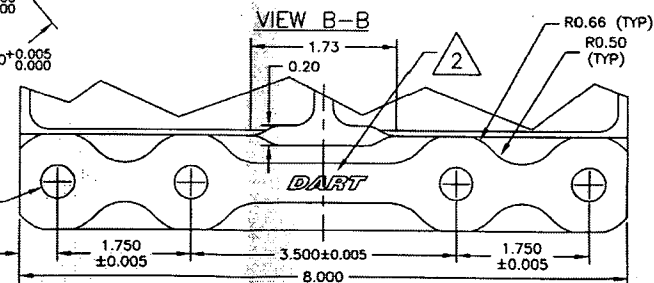
$\triangle E$






SECTION A-A



DETAIL C
SCALE 4:3



E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN DS		DRAWN BY PH
		DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED 	APPROVED 	DRAWING NO. D2571
DATE 05.07.13		TITLE OUTER FWD SADDLE
		REV. E SHEET 1 OF 1 SCALE 2:1

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